

Date: Thursday, 11/23/2006 11:53:20 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE
Job Number	: 29664		
Estimate Number	: 11545		
P.O. Number	: <i>N/A</i>	Part Number	: D204635011
This Issue	: 11/23/2006 S.O. No. : <i>N/A</i>	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 29278	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/10/2006 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i> 061123		
Comment	: Est Rev: 02.08.28 Removed QC5 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011 CHG004

*KS 06-11-28*

2.0

29664A

SKIDTUBE



Comment: Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D204-635-041	Skidtube Assembly	<i>B29664A</i>

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

K10003

D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	<i>B28979</i>

*PC 6/12/14*

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*C 206/12/14*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: LC Date: 06/12/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29664

Part Number: D204635011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

B

10/6/12 14 (1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/6/12/15 (1)

Job Completion



U 06/2-15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:49 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE  
 Job Number : 29664A  
 Estimate Number : 11546  
 P.O. Number : *N/A* Part Number : D204635041  
 This Issue : 11/23/2006 S.O. No. : *N/A* Drawing Number : D2590 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : C  
 Previous Run : 29278A Material : *N/A*  
 Due Date : 12/10/2006 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]* 061123  
 Comment : Est Rev: F 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D25001190 Ex'n -1" Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total: 1.0400 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion 24669

*Pm/ JB 06/11/30 ①*

2.0 D2597 204 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2597 204 Web 29675

*Pm/ JB 08/12/01 ①*

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

*Pm/ JB 06/11/30 ①*

2-Cut D2500-1-190 per Dwg D2590 .Deburr ends

*Pm/ JB 06/11/30 ①*

3-Drill pilot holes using drill jig DT 8149 & DT8711-1&-2

*Pm/ JB 06/11/30 ①*

4-Acid etch and Alodine tube per QSI 005 4.1

*~~06-11-30~~ Pm/ JB 06/11/30 ①*

5-Open holes to 0.500" as per Dwg D2590 without cutting fluid

*Pm/ 06-11-30 ①*

6-Countersink holes as per Dwg D2590 without cutting fluid

*Pm/ 06-11-30 ①*

7-Deburr and blow out all chips from inside of tube

*Pm/ 06-11-30 ①*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:49 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29664A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date: 07/02/101

Start Time: 7:10

Fin Time: 10:10AM 6-12-4

4.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

DP 6-12-4

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590

2-Deburr ends after cutting. Remove alodine from around holes

DP 6-12-4  
MA 06/12/05 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-12-11

7.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3

Step

B29486 BE 06-12-11

8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 D2579

Spacers

B29603 BE 06-12-11  
06-11-1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



Date: Thursday, 11/23/2006 11:53:49 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29664A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

LARGE FAB 1

\* LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1-Prepare tube for welding D2576-3 Step Remove alodine as required. *BE 06-12-11*
- 2-Weld step D2576 as per Dwg. D2590 and QSI 004  
A/R Aluminum Rod *M101446 BE 06-12-11*
- 3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R Aluminum Rod *M101446 BE 06-12-11*
- 4-Grind welds as per Dwg D2590 Grind flush ridge made from bending *JP/PM 06-11-12*
- 5-Drill holes for wearplates using DT 8218 Open holes to 19/64", adjust stopper not to hit crosstubes. Deburr *PM 06-12-12 (1)*
- 6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Deburr holes *PM 06-12-12 (1)*
- 7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr *PM 06-12-12 (1)*
- 8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr *PM 06-12-12 (1)*

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 06-12-12 (1)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*J. 06-12-12*

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*M102391*



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

*M.H./d.m 06/12/13 (1)*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Y/L 06/12/13 x 1*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:49 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29664A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	B28063

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B28013

16.0

D25777

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-7	Wearplate	B21607

17.0

D25941

Plug



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-1	Plug	B28014

18.0

D25943

O-Ring



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-1	Plug	B27168

a.m. 06/12/13 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29664A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

B 26351

20.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

38

ALS7-1032-130

Inserts

M18964

21.0

AN960JD10L

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

8

AN960JD10L

Inserts

washer

M102217

22.0

AN34A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

38

AN3-4A

Bolt

M102082

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

M15205

a.m

06/12/13

①

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2590. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M102107

Sikaflex expire date: 02/07

a.m

06/12/13

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/2/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29664A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 *M102107*

Sikaflex expire date: *08/27*

*a.m 06/12/13*

*(1)*

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

*M102635*

*m-h / a.m*

Batch:

*06/12/13*

25.0

QC5

INSPECT WORK TO CURRENT STEP



*06/12/13*



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

26.0

QC21

FINAL INSPECTION/W/O RELEASE



*fine*



*(1)*

Comment: FINAL INSPECTION/W/O RELEASE

*06/12/15*

Job Completion



*U 06.12.15*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/11 BS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

# 08-28  
P 08-28

EFFECTIVE DEOS

98/12/14
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#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 189.5 INCHES \*
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

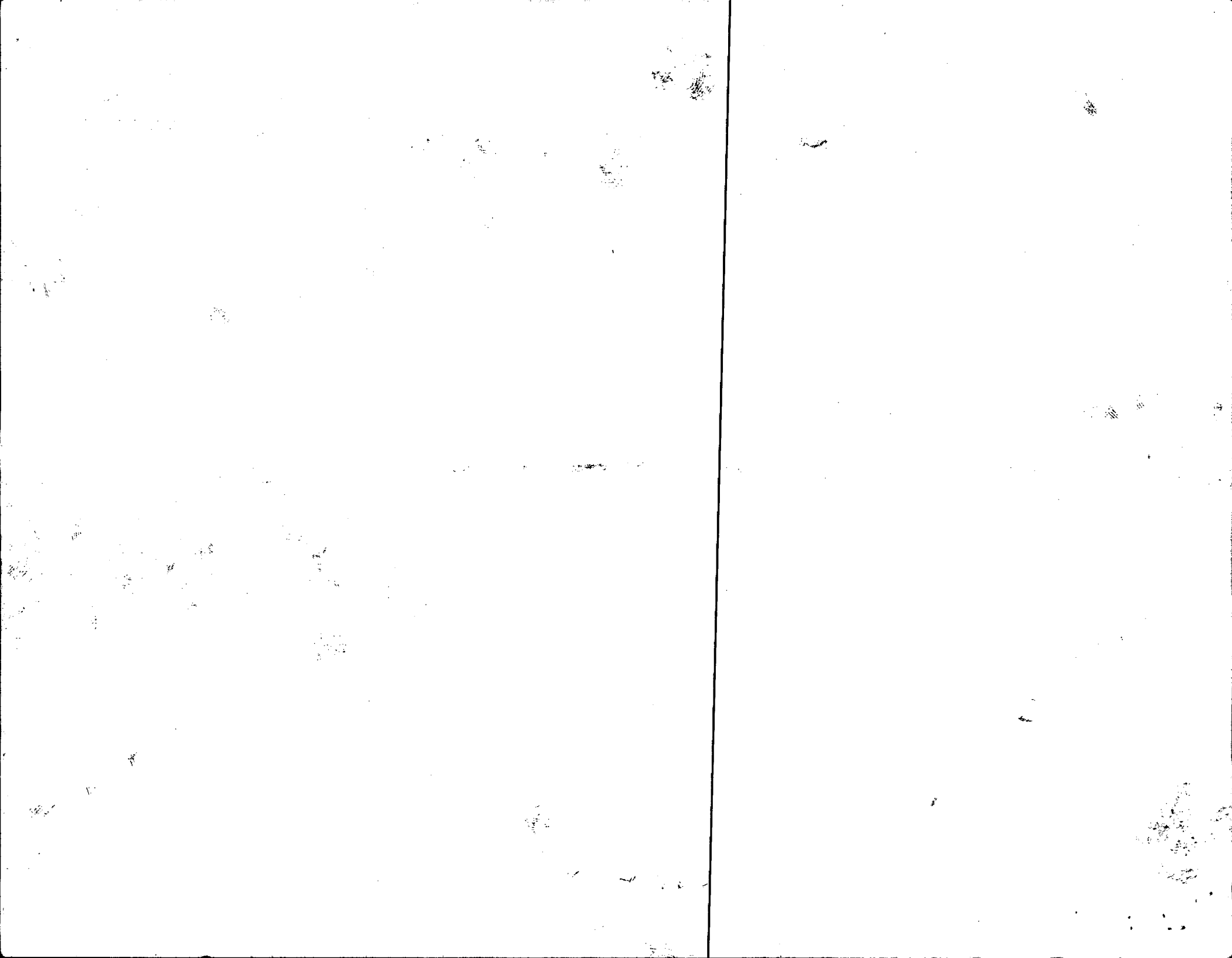


Diagram illustrating the grinding locations on the underside of the propeller. The diagram shows a cross-section of the propeller with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- STEP
- $\frac{1}{8}$

Technical drawing showing a detail of a bolted connection. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
- #0.208
- AN3-4A BOLT (1)
- AN960JD10L WASHER (1)
- (2 PLACES)
- D2575 CAP
- SEAL WITH SIKAFLEX-241
- 0.40

D2579 SPACER

WEB (REF)

1.75 (REF)

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (17 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

[illegible][illegible]

D2577-41 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

1.5 1.5 1.5 1.5

0.5

D

P P P P

REFER TO DETAIL C

D2577-3


D2577-7

D2577-1

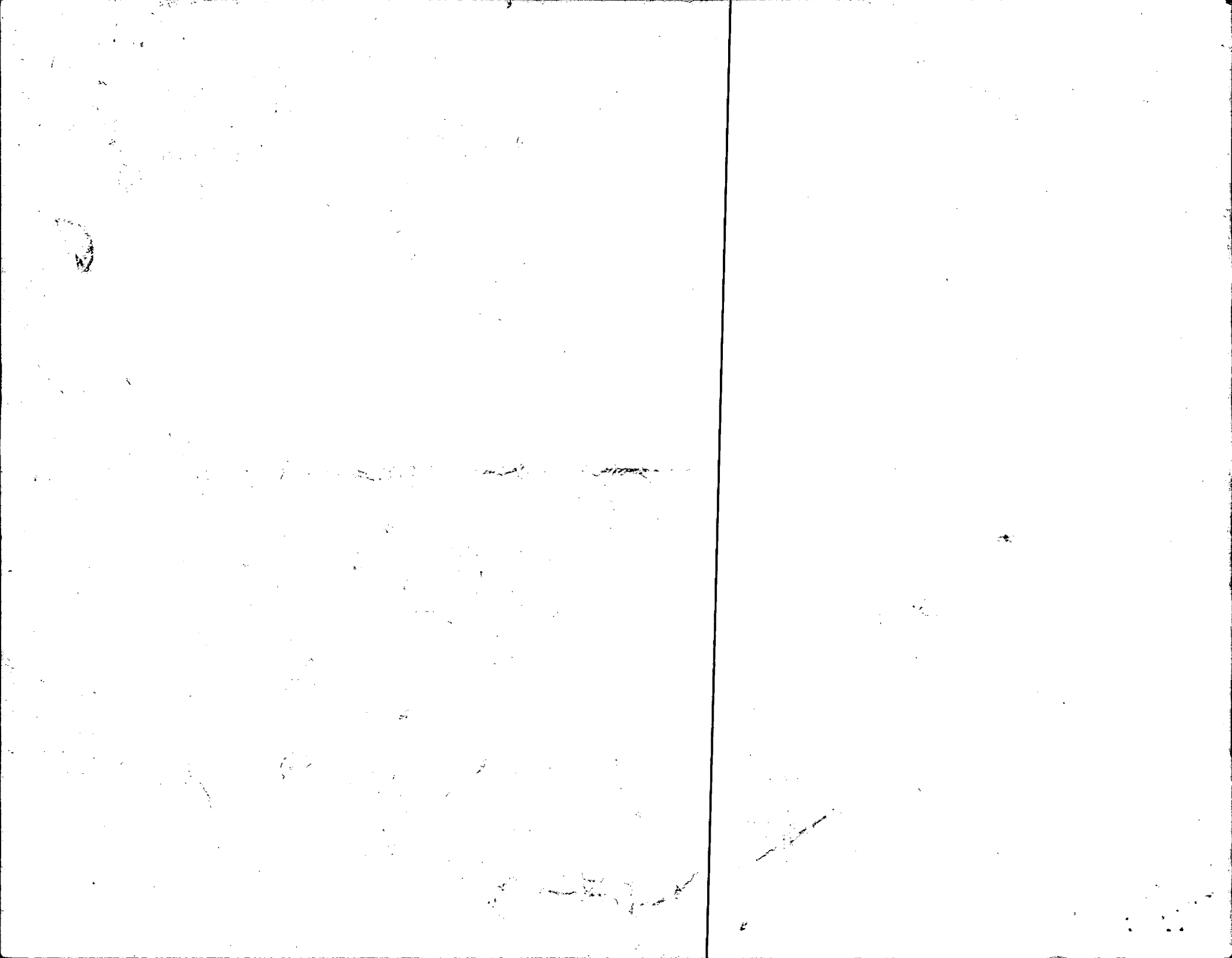
AN3-4A BOLT (1)  
AN960J10L WASHER (1)  
(38 PLACES)

8

RELEASE  
98/09/17 DS

DESIGN <i>RAH</i>	DRAWN BY <i>CS</i>	 <b>DART AEROSPACE LTD</b> HAMILTON, ONTARIO, CANADA
CHECKED <i>RAH</i>	APPROVED	
DATE 98.08.28	DRAWING NO. D2590 REV. C SHEET 2 OF 2 SCALE 1:24 TITLE 204 SKIDTUBE ASSEMBLY	

02597 W  
 AL57-1032-1  
 (TYP 38)  
 SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 29664A



NO. 81

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number D204 635 011 / B29664 A

TEST WELDS REQUIRED

BASE METAL	<u>Aluminum</u>	WELDING PROCESS	<u>Tig</u>
Penetration	Complete <input type="checkbox"/> Partial <input checked="" type="checkbox"/>	Single Weld <input checked="" type="checkbox"/> Double Weld <input type="checkbox"/>	
Current	AC <input checked="" type="checkbox"/> DC <input type="checkbox"/>	Backing	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>
	Position	Vertical	Down <input type="checkbox"/> Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/>	3G <input type="checkbox"/> 4G <input type="checkbox"/>	
Tube Groove	1G <input type="checkbox"/> 2G <input type="checkbox"/>	5G <input type="checkbox"/> 6G <input type="checkbox"/>	
Sheet Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/>	3F <input type="checkbox"/> 4F <input type="checkbox"/>	
Tube Fillet	1F <input type="checkbox"/> 2F <input type="checkbox"/>	4F <input type="checkbox"/> 5F <input type="checkbox"/>	
Crossbolt Spacer	Welded into	Skidtube	

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06-12-08

Qualifier Pat. Dal.